	<b>er ID 107</b> 4 otember 25, 2013			*107					Page 1			
Item ID: Revision ID: Item Name:	D2252-7 Frame			Accept	*N900	)*	Setup	Start Stop	IV	IS1* IS2*		
Start Date: Required Date: Reference:	9/25/2013 S	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item :	ID:					IN	
Approvals:	Process Plan: QC:		Date: 13-9-25	Tooling: SPC (Y/N):		ate:			Run	Start Stop	!/	IR1* IR2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Re Qt	ject y	Reject Number	Insp. Stamp
Draw Nbr	Revisi	on Nbr										
D2252	G											
140				0.00								
*140* QC Quality Control		Memo PULL FROI	M STOCK D2252-1 X 5 B#8	0.00 86300				_5_		Sk	10_	13-09-2
		PARTS AR	E ACTUALLY D2252-7									
906		RE-IDENTI	FY USING NEW BATCH N	UMBER		DAS 27		<				
*150	Id	dentify as per dwg & St	ock Location: UJA	0.00 SAV 0.00 13-09-	B	9.89 9.05	S	<u> </u>				
Packaging		Mama		000 13-09-	77 ·	•						

ID AND STOCK UNDER NEW BATCH NUMBER

**Packaging** 

WA. MT 13 9-25

DQA:		_ Date:		· · · · · · · · · · · · · · · · · · ·		DART								
QA Closed:		Date:			WORK ORDER NON	AEROSPACE								
Work Orde	er:				DISPOSITION									
Part N	lo				Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstu  Machining Small I  Thermoforming Finish  Large Fab Compos			Fab Prod. Eng. Coor hing Rec/Store/Packaging				Engineering Quality Other
Root				Desci	ription of work order update	!	Initial	Ac	tion		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Design Doc/Data														
Equip/Tooling		•												
Handling/Pre	_													
Material	_													
Operator	-					ļ								
Offset/Setup	-													
Process	_													
Supplier														
Training														·
Transport														
Unapproved							:							
			•			FAI	ULT CAT	EGORY				<u> </u>		
Landin	ng Gear				General									
	Bending				Bend		Folio/P	rogram			Outside Dim	ensions	Г	Pressure/Forced
	Centre N	ot Concer	ntric		BOM/Route		Grain	· ·		Г	Over/Under	tolerance	Г	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred			Temperature/Cure
	Crimp/Kink/Ripple/Wave				Burrs		Inspecti	on Incomplete/Ui	nqualified		Part Lost/Mi	ssing		Weld
	Cuffs				Contamination		Instruct	ions Incomplete/I	Jnclear		Part Moved	Ü		Wrong Stock Pulled
Crushing				Countersink		1	ned/off center			Positioned V	ا Vrong	_	, ~	
Heat Treat				Cut Too Short		Mislabe				Power Loss/:	· ·		Other	
	Inspectio	n Strip in	Tube		Drawing		Misread	l.			<b>.</b>	-	_	
	Marks/Cl	hatter			Drill Holes		Off-set							
	Turning S	Sequence			Finish		Out of C	alibration						
Ī	Wave/Twist in Tube				Fit/Function		Out of Sequence							

Sequence ID/

\*160\*

Quality Control

160

**Work Center ID** 

Operation

Description

QC21- Final Inspection - Work Order Release

Memo

Work Ord Wednesday, Se		<b>)7474</b> 013 12:47:51 P		*10			Page 2	
Item ID: Revision ID: Item Name:	D2252-7 Frame			*N900040100*				*NS1* *NS2*
Start Date: Required Date Reference:	9/25/2013 e: 9/26/2013	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item ID: Customer:			
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	Date: Date:	Run	Start Stop	*NR1* *NR2*

Tool ID

Tool # Plan

Code

Accept

Reject

Qty

Reject

Set Up/

0.00

0.00

Run Hours

MF 925

Insp.

Number Stamp

DQA:		. Date:			−											
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only											
Work Order:					DISPOSITION											
Part No					Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Prod. Eng. Coor. ng Rec/Store/Packaging				Engineering Quality Other			
Root				Descr	ription of work order update	1	nitial	Act	ion		Sign &					
Cause	Date	Step	Qty		or non-conformance		ief Eng	Descr	iption		Date	Verification		QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved																
		<u> </u>	·			FAL	JLT CAT	TEGORY					1.			
Landing	Gear				General						10110					
	Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspection Marks/Ch Turning So	t strip in atter	/Wave		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration				Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance et ssing /rong	Se Te Wi	essure/Forced t-up mperature/Cure eld rong Stock Pulled her		
	Wave/Tw		e	-	Fit/Function	Out of Sequence						· · · · · · · · · · · · · · · · · · ·		-		

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Wednesday, September 25, 2013 12:47:50

Work Order ID:

107474

Parent Item:

D2252-7

Parent Item Name:

Frame

**Start Date:** 9/25/2013

**Required Date: 9/26/2013** 

Page 1

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A 10.09.08 new issue verf:EC

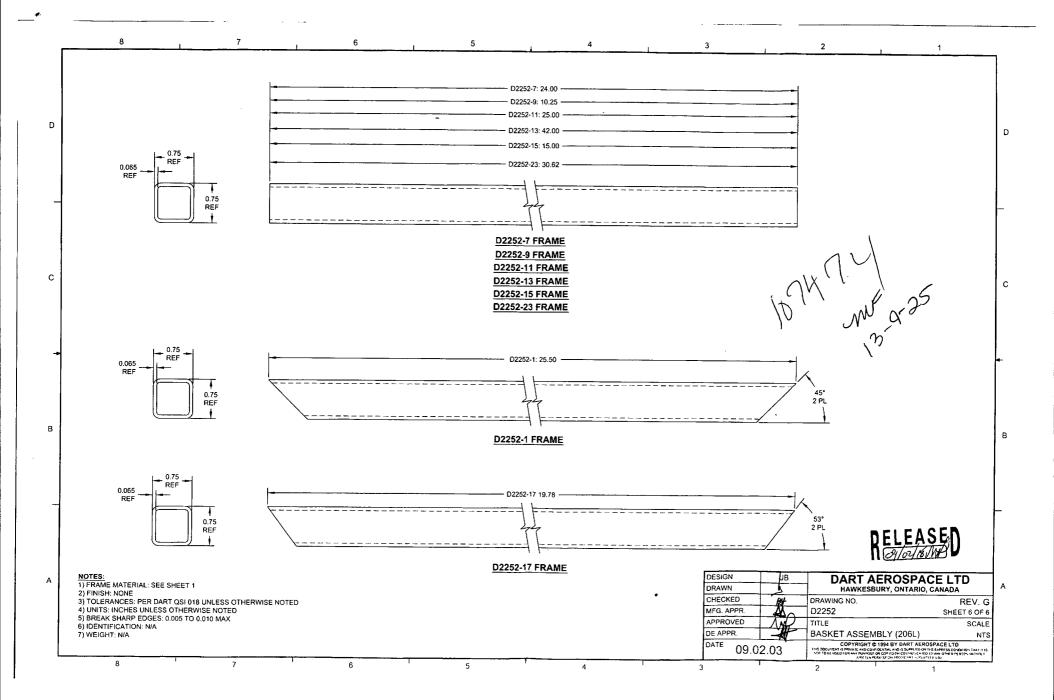
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2252-1		Manufactured	No				Each	4.0000		5			
Frame		ivianulaciui cu						1.0000		3			

 Location
 Loc Oty
 Loc Code

 WA005
 4

 91047
 4

DQA:		- Date:	•		<b>*Λ</b> Δ!										
QA Closed:		Date:			WORK ORDER NON	AEROSPACE									
Work Order					DISPOSITION										
WOIK OIGE	•				Dawa di	1		مان داداد		1	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	_	- · · □		
Part No	2				Rework Scrap			<del></del>	sstube	Water Jet			Engineering		
raitive	J			<del></del>	Use-as-is		· —	nall Fab nishing	Prod. Eng. Coor.			Quality			
NCR No	า				Suspected Unapproved	1	men	- <del>-</del>	nposite	·			Other		
,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	·				Juspected Onapproved	j		Large rab Com	iposite[	1	Supplier	<del>,                                    </del>			
Root		<u> </u>	· ·	Desci	ription of work order update	П	nitial	Action		Sign &		T			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	,	QC Inspector		
Design								· · · · · · · · · · · · · · · · · · ·							
Doc/Data															
Equip/Tooling		ļ													
Handling/Pre															
Material															
Operator															
Offset/Setup															
Process															
Supplier															
Training															
Transport		•	ľ												
Unapproved															
						FAL	ULT CAT	EGORY							
Landing	Gear			,	General					_	_		***		
-	Bending				Bend		Folio/P	rogram		Outside Dim	ensions [	P	ressure/Forced		
ļ	Centre No	ot Concer	ntric	Щ	BOM/Route	Ш	Grain			Over/Under	tolerance	S	et-up		
<u> </u>	Cracks			Ш	Broken/Damage/Defect		Hardwa	re		Part Incorred	rt [		emperature/Cure		
_	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Unqualifie	ed	Part Lost/Mi	ssing	v	Veld		
	Cuffs				Contamination		Instruct	ions Incomplete/Unclear		Part Moved	. [	v	Vrong Stock Pulled		
	Crushing			-	Countersink		Misalig	ned/off center		Positioned W	/rong _				
	Heat Treat				Cut Too Short	Ш	Mislabe	led		Power Loss/S	Surge	o	ther		
-	Inspection	٠,	Tube		Drawing		Misread	Į.							
<u> </u>	Marks/Ch				Drill Holes		Off-set								
<u> </u>	Turning S				Finish	<del></del>	ł	Calibration							
	Wave/Tw	ist in Tub	e		Fit/Function Out of Sequence										



DQA:		·····	Date:												\ DT	
						WORK ORDER NON	I-C	ONFO	RMANCE	/ UPDATE				A E	ROSPACE	
QA Closed:			Date:			Work Order update only										
Work Ord	er:					DISPOSITION				AGAIN	ST DE	PARTMENT	/PROCESS			
	-			-		Rework	7		Skid-tube	Crosstu	be		Water Jet	Engine	ering	
Part I	No					Scrap			Machining	Small F	ab	Pro	d. Eng. Coor.		uality	
	·			<del></del>	Use-as-is		Therr	Thermoforming Finishing			Rec/Sto	re/Packaging		Other		
NCR I	NCR No.				Suspected Unapproved			Large Fab	Compos	ite	]	Supplier	<u>.                                      </u>			
Root		_			Desc	ription of work order update		Initial		Action		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	[	Description		Date	Verification	n QC Ir	spector	
Design	Щ															
Doc/Data	Ш						]						·			
Equip/Tooling	Н															
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Material	$\blacksquare$															
Operator	H															
Offset/Setup Process	Н											}				
Supplier	H															
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			4				FA	ULT CAT	TEGORY				<u></u> .			
Landi	ng G	ear				General								· · · · · · · · · · · · · · · · · · ·	-	
		Bending				Bend		Folio/P	rogram			Outside Dim	ensions	Pressure/	Forced	
		Centre No	ot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up		
	Щ	Cracks				Broken/Damage/Defect	L	Hardwa	re			Part Incorred	ct	Temperat	ure/Cure	
	-	Crimp/Kin	k/Ripple	/Wave		Burrs		Inspecti	on Incomple	te/Unqualified		Part Lost/Mi	ssing	Weld		
	-	Cuffs				Contamination		Instruct	ions Incompl	ete/Unclear		Part Moved		Wrong Sto	ock Pulled	
	$\overline{}$	Crushing				Countersink		Misalig	ned/off cen	iter		Positioned W	Vrong _		•	
	Heat Treat					Cut Too Short		Mislabe	led			Power Loss/	Surge	Other		
	Inspection Strip in Tube					Drawing		Misread	ł							
	-	Marks/Ch				Drill Holes		Off-set								
:	_	Turning Se			_	Finish		1	Calibration							
k		Wave/Tw	ist in Tub	e		Fit/Function	1	Out of S	equence							

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